

## Work Order ID 68314

Monday, April 11, 2011 1:37:11 PM



Page 1

Item ID: D3542-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/11/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: PL Date: 4/11/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3542	Rev A	

100 0.00

	BAND SAW	
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	Memo	0.00
--	------	------

	Cut blank 4.0" long	
--	---------------------	--

*Jeff 11.05.10*

*10 \$*

110 0.00

	HAAS CNC VERTICAL MACHINING #1	
--	--------------------------------	--

	Memo	0.00
--	------	------

	1- Mill as per Folio FA684 Rev: <u>AA</u> & Dwg D3542 Rev: <u>A</u> <input type="checkbox"/> 2-Deburr per dwg D3443	
--	--	--

*11.05.11*

*Jeff 11.05.10 P\$*

120 0.00

	QC2- Inspect parts off machine FAI/FAIB	
--	---	--

	Memo	0.00
--	------	------

--	--	--

*Jeff 11.05.10*

*10 \$*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 68314**

Monday, April 11, 2011 1:37:11 PM



Page 2

Item ID: D3542-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/11/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC8- Inspect parts - second check

0.00

JL 11/05/11

(10)

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Hand Finishing

Memo

0.00

10 BL 11-5-12

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

0.00

\*\*\*\*\*ENSURE TO MASK INSIDE BORE\*\*\*\*\*  
START TIME:  
OVEN TEMPERATURE: 1250  
FINISH TIME:  
TIME: 2:20

10x Ø M2 11/05/13

11/15/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**Work Order ID 68314**

Monday, April 11, 2011 1:37:11 PM



Page 3

Item ID: D3542-1

Accept



Setup

Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/11/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

11/15/11 SF 102

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 245

0.00

11/15/11 102 SF

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/15/11 JJ

P11-0514  
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Monday, April 11, 2011 1:37:17 PM

Page 1

**Work Order ID:** 68314**Parent Item:** D3542-1**Parent Item Name:** Bracket**Start Date:** 4/11/2011**Required Date:** 4/15/2011**Start Qty:** 10.00**Required Qty:** 10.00**Comments:**  
IPP Rev: A New Issue 07-04-23 JLM  
IPP Rev: B updated powder coat per NCR 07.05.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B30000X01.5 00		Purchased	No			100	f	15.5000	0.3333333	3.333333			

6061-T6 Bar 3.00 x 1.50

Location	Loc Qty	Loc Code
MAT010	15.5	
109058	5	
114468	10.5	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68314
Description: Bracket	Part Number:	D3542-1
Inspection Dwg: D3542	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>Surf</u>	Audited by:	<u>SL</u>	Prototype Approval:	N/A
Date:	11-05-10	Date:	11/05/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EZ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

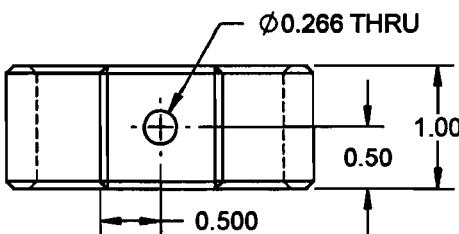
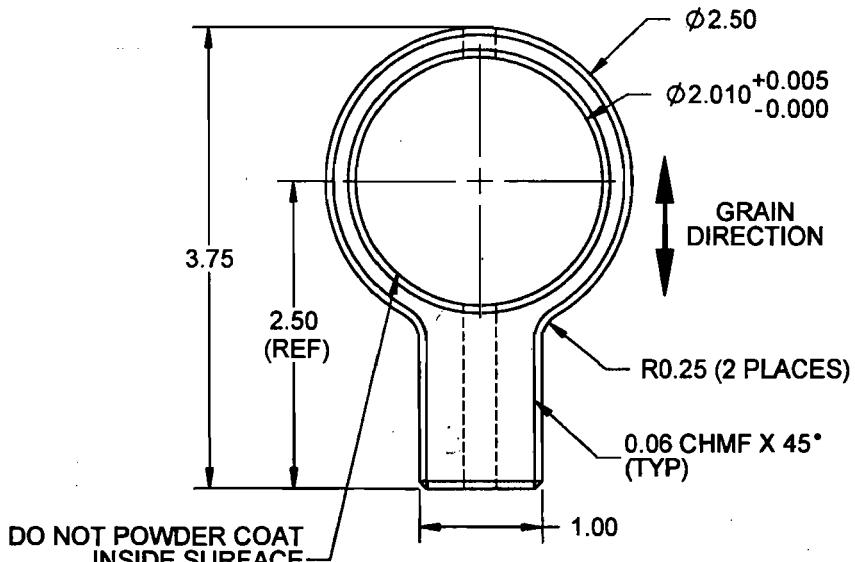
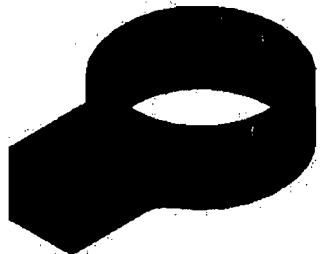
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3542	REV. A	SHEET 1 OF 1
DATE 06.11.27		TITLE BRACKET	SCALE	2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE		

**RELEASED**  
07.04.02**D3542-1 BRACKET**

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *G8314*

*11/11-04-11***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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